

Date: Thursday, 20/11/2008 3:33:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NO STEP LABEL
Job Number : 43594	
Estimate Number : 10160	
P.O. Number :	Part Number : D2137
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2137 REV 93.29.06
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : PURCHASED PARTS	Drawing Revision : 93.29.06
Previous Run : 43312	Material :
Written By :	Due Date : 05/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est: B 02.02.01 Added step 3 and Inspection level 21 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O 7659

Make per Dwg 2137

C2081/24

(20)

2.0	D2137P	Decal - No Step
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

DECAL- NO STEP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C844/27

(20)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



caution

Comment: INSPECT WORK TO CURRENT STEP

C081/29

(20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



(20)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 13

8/11/28

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:33:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NO STEP LABEL

Job Number: 43594

Part Number: D2137

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/01 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-28

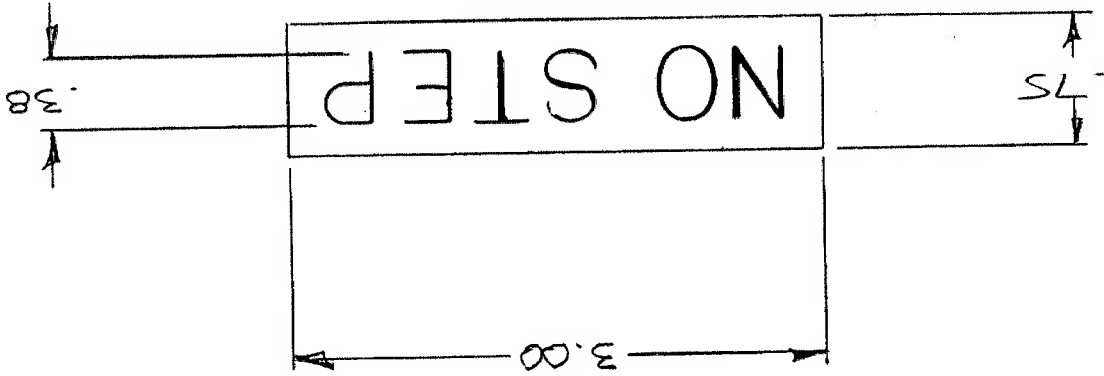
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MATERIAL: 3M ROLLESTER

NATURAL (SILVER OR WHITE) ON BLACK.
 .003 THICK



2137

4000.09.05
 4000.09.05

ALTERNATE MATERIAL:
 7 MIL MAKING FILM #8522CP

SHOW COPY
 RETURN TO
 3M
 ENGINEERING

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 73594

REVISION		DRAWN		APPROVED		DESCRIPTION		CHANGE	
THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COVERED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		LIMITS		TOLERANCES - UNLESS OTHERWISE SPECIFIED		1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES ARE AS SHOWN 3. MATERIALS SHALL BE AS SPECIFIED 4. DIMENSIONS PER MIL - S - 1147 5. UNLESS PER MIL AND 10007	
BASIC CODE		D-DRAWING CODE		BASIC CODES		BASIC CODES		REPORT ALL DISCREPANCIES - DO NOT SCALE	
ON DASH NO. HEAD REAR SIDE		D-DRAWING CODE		BASIC CODES		BASIC CODES			
CONTRACT NO.		D-DRAWING CODE		BASIC CODES		BASIC CODES			
PART NO.		D-DRAWING CODE		BASIC CODES		BASIC CODES			
ITEM		D-DRAWING CODE		BASIC CODES		BASIC CODES			
DESCRIPTION		D-DRAWING CODE		BASIC CODES		BASIC CODES			
MATERIAL		D-DRAWING CODE		BASIC CODES		BASIC CODES			
SPEC/VENDOR		D-DRAWING CODE		BASIC CODES		BASIC CODES			
DART AERO ACCESSORIES INC. CANADA		D-DRAWING CODE		BASIC CODES		BASIC CODES			
DART		D-DRAWING CODE		BASIC CODES		BASIC CODES			
Vancouver		D-DRAWING CODE		BASIC CODES		BASIC CODES			
TITLE		D-DRAWING CODE		BASIC CODES		BASIC CODES			
DECAL - NO STEP		D-DRAWING CODE		BASIC CODES		BASIC CODES			
DWG NO.		D-DRAWING CODE		BASIC CODES		BASIC CODES			
D 2137		D-DRAWING CODE		BASIC CODES		BASIC CODES			
SHEET 1 OF 1		D-DRAWING CODE		BASIC CODES		BASIC CODES			



Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

Product Bulletin 8522

Release F, Effective January 2003
Black bar in margin indicates a change

- Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slipage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www.scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

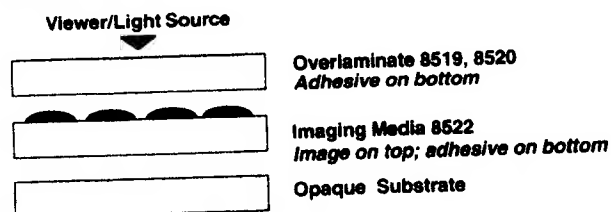
Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.





210 MAI W.,
HAWKE: BURY, ONT. K6A 2H6
Tel.: 613 332-2001
Fax: 613 332-9491
www.studiolettrage.com

INVOICE / FACTURE

No.: 11374
DATE: 11/27/2008
PAGE 1 of 1
Re: Quote No. 6151

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMOUNT MONTANT
	20	-	D2137P set up	E		2.5000	50.00
	10	✓	D3268P set up	E		5.0000	50.00
	10	-	D33011P set L	E		5.0000	50.00
	10	-	D33091P set L	E		5.0000	50.00
	6	-	D33093P set L	E		8.3333	50.00
	1	-	printing batch	G		50.0000	50.00
			E - GST @ 5%				
			G - GST @ 5% PST @ 8%				15.00
			GST				
			PST Exempt: # 122-5207				
Studio de Lettrage GST: #869034678RP001						TOTAL	315.00
PO 7659							

Sold By:

Merci! Thank You!

**Purchase Order**

Date Nov 24, 2008	Page 1
Purchase Order Number PO00007659	

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

REFERENCE ONLY**Vendor Address:**

Studio de Lettrage 2001
210 Main West
Hawkesbury, ONT K6A 2H6
Canada
Phone (613) 632-5449
Fax (613) 632-9491

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-STU001	Nov 24, 2008	N30	yours	Nov 28, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
20.0000	D2137P ✓	Decal - No Step Comments: AS PER WG D2137 REV. 93.29.06 B43594	28/11/2008	No	3.750000	Each	75.00
✓ 10.0000	D32681P ✓	Placard Comments: AS PER WG D3268 REV. A B43643	28/11/2008	No	4.375000	Each	43.75
10.0000	D33011P ✓	PLACARD Comments: AS PER WG D3301 REV. A B43658	28/11/2008	No	7.500000	Each	75.00
✓ 10.0000	D33091P ✓	Label Comments: AS PER WG D3309 REV. A B43659	28/11/2008	No	5.000000	Each	50.00
6.0000	D33093P ✓	Label Comments: AS PER WG D3309 REV. A B43660	28/11/2008	No	5.000000	Each	30.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:**Tax Summary:**

GST 13.69
GSTME 0.00
GSTND 0.00

Less:

included tax

0.00

Subtotal

273.75

Total tax

13.69

Total purchase order in

CAD Dollars

287.44

Entered By: *CL* CLAVOIE

Approved By: *[Signature]*